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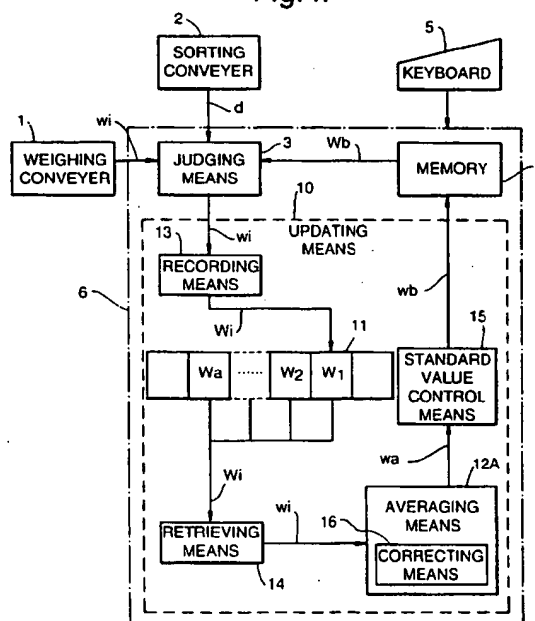
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(54) **Weight checker-sorter.**

(57) A weight checker-sorter successively weighs products each expected to contain a specified number of articles all weighing about the same, and uses a standard weight value (W_b) to determine whether weighed products each contains the intended number of articles. Measured weights of products within a predefined range are stored. The standard weight value is updated frequently by averaging a specified plural number of most recently stored weights.

Fig.4.



This invention relates to a weight checker-sorter, which is an apparatus for weighing products intended to contain a specified number of articles to thereby determine whether each weighed product contains more or less than the specified number of the articles and to sort the weighed products accordingly.

When products to be sold are in the form of a box or a package containing a specified number of articles, it has been known to make use of a weight checker-sorter such as described in Japanese Utility Model Publication Jikko 3-1101 to examine whether each product actually contains the specified number of the articles. As schematically shown in Fig. 6, such a weight checker-sorter may include a sorting conveyor 2 (serving as a sorter) disposed on the downstream side of a weighing conveyor 1 (serving as a weigher). A pusher 2a disposed near the sorting conveyor 2 is adapted to push each product A off the sorting conveyor 2 if it is determined not to contain a pre-selected intended number of articles a.

Having measured the weight of the product A, the weighing conveyor 1 outputs a weight signal w_i indicative of the measured weight value W_i to a judging means 3, as shown in Fig. 7. The judging means 3 compares the weight value W_i with a standard value W_b stored in a memory means 4. If the difference ($W_i - W_b$) is within an allowable limit, the weighed product A is considered to have "passed" the test. If the difference is not within the allowable limit, it is concluded that the number of the articles contained in the product A is either too large or too small, and a defect signal d is outputted from the judging means 3 to the sorting conveyor 2.

The standard value W_b is initially inputted from a keyboard 5 but is thereafter updated by an updating means 10, which includes a memory means 11 and an averaging means 12. The memory means 11 serves to successively store measured weight values W_i of products A which have been considered by the judging means 3 as having "passed" and the averaging means 12 serves to calculate a simple average of a plural number n of weight values W_1, W_2, \dots, W_n and to obtain therefrom an average value W_a . Thereupon, the updating means 10 outputs a standard value signal w_b to cause the average value w_a to be stored in the memory means 4 as the new standard value W_b , thereby updating the standard weight value.

The weight of the articles a shown in Fig. 6 changes gradually during their production process due to variations in the ambient temperature and production errors. As a result, there are fluctuations in the measured weight W_i of the products A. The prior art technology described above teaches how to adjust to such fluctuations by introducing a new standard weight value through an averaging process on earlier obtained weight values W_i .

The weight W_i of the products A, however, does not always change gradually. When articles from a

new lot have been introduced or when the production process has been interrupted, for example, the weight W_i of the product A may change suddenly. Consider the process shown in Fig. 8(a), for example, of filling containers 51 with a semi-liquid L from a hopper 50. The hopper 50 may be provided with a screw conveyor 52 for delivering a fixed amount of the semi-liquid L into the container 51 placed below. The hopper 50 may be provided also with a level sensor 53 such that, as soon as the top level of the semi-liquid L in the hopper 50 drops below its level, semi-liquid L from the next lot is dropped inside the hopper 50 as shown in Fig. 8(b). This causes an increase in the pressure near the bottom outlet 54, and the amount of the semi-liquid L delivered into the container 51 increases suddenly, as shown also in Fig. 8(b). As a result, both the article weight and the product weight not only change gradually but also increase suddenly, as shown by solid lines in Figs. 3(a) and 3(b).

In such a situation, the measured product weight W_i may become greater than the allowable upper limit (which is the sum of the standard W_b and the weight a of a single article, or $W_b + a$) although the product may in fact be containing the specified number of the articles. In other words, the prior art technology cannot adjust quickly enough to a situation where there is a sudden change in the article weight.

In accordance with the present invention, a weight checker-sorter comprises a weighing means for weighing a product expected to contain a specified plural number of articles; judging means for determining whether or not said product, weighed by said weighing means, contains said specified plural number of said articles by comparing a measured weight value obtained by said weighing means and a current standard value; weight memory means for storing weight values of products which have been considered acceptable by said judging means; updating means for calculating a new standard value from a plurality of weight values stored in said weight memory means; and sorting means for sorting products weighed by said weighing means according to determinations by said judging means and is characterised in that said updating means includes averaging means for calculating an average once every n' times as new weight values are stored in said weight memory means, said average being of the n most recently stored values, n and n' being integers, and n being greater than n' .

The present invention provides a weight checker-sorter of the type for judging whether a given product contains an intended number of articles or not from the measured weight of the product, capable of adjusting itself quickly when there is a sudden change in the article weight such that sorting can be effected with improved accuracy.

Thus, the weight checker-sorter comprises means for calculating an average of a certain plural

number (= n) of weight values which have most recently been measured and determined to be within a required range and hence "acceptable". Such average values are calculated once every n' times such an acceptable weight is measured where n' is an integer smaller than n.

The principle of this invention will be explained next with reference to Figs. 3(c) and 3(d). Let us assume that products, all expected to contain a specified plural number of articles of approximately the same weight, are successively being weighed. Measured weights which are within a certain range and hence considered acceptable are successively stored such that n of those weight values which were most recently stored are always available. At any moment, let W_1 denote the weight value which was most recently stored as being acceptable, and let generally W_j (j being a dummy index 2, ... n) denote the weight valued stored jth most recently. Every time a measured weight value is found to be acceptable and stored as W_1 , an average W_a of the n most recently stored weight values, inclusive of W_1 which has just been measured and stored, is calculated by a predetermined averaging formula or algorithm and is used as the new standard weight. When the next product is weighed, its weight value is compared with this updated standard weight and determined whether it is acceptable or not. In other words, the standard weight value is updated as soon as a product is weighed and determined to be acceptable. Thus, as shown in Figs. 3(c) and 3(d), the standard weight W_b changes quickly as the weight of individual articles, and hence also the weight of a product suddenly increases.

The accompanying drawings, which are incorporated in and form a part of this specification, illustrate an embodiment of the invention and, together with the description, serve to explain the principles of the invention. In the drawings:

Fig. 1 is a schematic structural diagram of a weight checker-sorter according to a first embodiment of the invention;

Fig. 2 is a flow chart for the operation of the weight checker-sorter of Fig. 1;

Fig. 3(a) is a graph for showing an example of the way article weight may change as the articles are produced, Fig. 3(b) is a graph for showing the way product weight may change corresponding to the change in article weight shown in Fig. 3(a) if a prior art checker-sorter is used, and Figs. 3(c) and 3(d) are graphs which show the change in product weight if use is made of a weight checker-sorter according to a first embodiment of the invention;

Fig. 4 is a schematic structural diagram of a weight checker-sorter according to a second embodiment of the invention;

Fig. 5 is a flow chart for the operation of the weight checker-sorter of Fig. 4;

Fig. 6 is a schematic plan view of a weight checker-sorter in general;

Fig. 7 is a schematic structural diagram of a prior art weight checker-sorter; and

Figs. 8(a) and 8(b) are schematic drawings for showing an example of machine for producing articles.

In these figures, components which are the same, or at least substantially similar, are indicated by the same numerals such as the weighing conveyer 1.

The invention will be described next by way of examples. In Fig. 1, which shows a weight checker-sorter according to a first embodiment of the invention, numeral 10 indicates a standard value updating means contained within a microcomputer 6 comprising a memory means 11 for storing at least a predetermined plural number (= n) of weight values which have been measured, an averaging means 12A for carrying out an averaging process, a recording means 13, a retrieving means 14 and a standard value controlling means 15, to be explained below. This weight checker-sorter is different from the prior art weight checker-sorter shown in Fig. 7 only in the standard value updating means 10. So, Fig. 1 will be explained next mainly regarding the standard value updating means 10.

When the recording means 13 of Fig. 1 receives from the judging means 3 a weight signal w_i corresponding to the weight value W_i of a product which is "passed" by the judging means 3, this weight value W_i is stored at the area in the memory means 11 where the oldest of the weight values currently in the memory means 11 is stored. Whenever a new weight value W_i is thus stored by the recording means 13 in the memory means 11, the retrieving means 14 retrieves from the memory means 11 the predetermined plural number n of weight values W_p ($p = 1, \dots, n$) which were stored most recently (inclusive of the value which has just been stored to initiate this retrieving operation) and to output weight signals w_p ($p = 1, \dots, n$) indicative of these n weight values W_p ($p = 1, \dots, n$) to the averaging means 12A. Throughout herein, W_1 denotes the weight value most recently stored in the memory means 11, W_2 denotes the second most recently stored weight value, and so on at any given time.

Having thus received the n weight signals w_p , the averaging means 12A calculates an average value W_a from the n most recently stored weight values. The average value W_a may be obtained by the following simple averaging formula:

$$W_a = (W_n + \dots + W_2 + W_1)/n. \quad (1)$$

Alternatively, W_a may be a weighed average and some of the weight coefficients may even be zero. In other words, expressions like "average" and "averaging" should be very broadly interpreted within the context of this invention.

The average value W_a calculated by the averag-

ing means 12A is outputted to the standard value controlling means 15 by an average value signal w_a . The standard value controlling means 15 checks whether the average value W_a is between a lower limit value $w_{b_{\min}}$ and an upper limit value $w_{b_{\max}}$ and to output one of these three values (W_a , $w_{b_{\min}}$ and $w_{b_{\max}}$) to a memory means 4 by a standard value signal w_b , as will be explained more in detail below, thereby replacing the currently stored standard value W_b .

A control program for carrying out the process described above will be explained more in detail below with reference to the flow chart shown in Fig. 2. After the program is started (Step S1), a product on the weighing conveyer 1 is weighed (Step 2), and a weight signal w_i indicative of its measured weight value W_i is outputted to the judging means 3. The judging means 3 then determines whether this weight value W_i is within a predefined range between $(W_b - \beta)$ and $(W_b + \alpha)$, that is, whether it "passes" or not as an acceptable product (Step S3). If it does not pass, it is sorted out and immediately discharged (Step S5). If it passes, the recording means 13 causes this weight value W_i to be stored in the memory means 11 as the most recently measured value W_1 , replacing the oldest of the memory values then stored in the memory means 11 (Step S4).

Next, the n most recently stored weight values W_n, \dots, W_2, W_1 (that is, inclusive of the weight value which has just been stored as W_1 in Step S4) are retrieved and an average value W_a is calculated therefrom by a predefined averaging formula or algorithm (Step S6). If W_a is determined to be smaller than a predefined lower limit value $w_{b_{\min}}$ (NO in Step S7) or greater than a predefined upper limit value $w_{b_{\max}}$ (YES in Step S7 or NO in Step S9), W_a is replaced respectively by $w_{b_{\min}}$ (Step S8) or $w_{b_{\max}}$ (Step S10) before W_a is stored as the new standard weight value, replacing the old standard value W_b thereby (Step S11), and ending the program (Step S12). In summary, since the standard weight value W_b is updated every time a newly measured weight value is "passed" as shown in Figs. 3(c) and 3(d), the weight checker-sorter thus controlled can quickly adjust itself to a sudden large change in the measured weight and hence the sorting can be effected with improved accuracy.

It is not necessary according to the present invention, however, that the averaging process for obtaining a new weight value W_a and the updating of the standard weight value W_b be carried out each time a weighed product "passes" as acceptable. It is still within the scope of the invention if the aforementioned steps of obtaining a new weight value W_a and replacing therewith the current standard weight value W_b are carried out once every n' times where n' is an integer smaller than n . It is also to be noted, as reminded above, that the averaging does not necessarily mean calculating a simple average by Formula (1).

As a special example, the "average" weight value W_a of n earlier obtained weight values W_p ($p = 1, \dots, n$) may be obtained by eliminating the largest and the smallest of them and then taking the simple average of the remaining weight values.

Figs. 4 and 5 are referenced next to describe a weight checker-sorter according to another embodiment of the invention characterized in that its averaging means 12A includes a correcting means 16. When the difference between weight values W_j and W_{j+1} , which are respectively the weight value stored in the memory means 11 j th and $(j+1)$ st most recently, is greater than a predefined difference value ΔW , this correcting means 16 corrects the value W_a and obtain a corrected value W_{a1} as follows:

$$W_{a1} = W_a + \sum C_j (W_j - W_{j+1}) \quad (2)$$

where C_j are correction coefficients such that $C_j > C_{j+1}$.

The correction method described above is explained next with reference to the flow chart of Fig. 5, in which the first six steps (Steps S1 - S6) are the same as in Fig. 2. After the average value W_a is calculated (Step S6), the program compares the j th and $(j+1)$ st most recently stored weight values W_j and W_{j+1} to determine whether their difference is greater than the predefined difference value ΔW or not (Step 20). This difference value ΔW may be set by multiplying α or β by a number smaller than 1. If the difference is smaller than the difference value (NO in Step S20), the newly calculated average value W_a is itself used as the corrected average value W_{a1} (Step S21). If the difference is equal to or greater than ΔW (YES in Step S20), the corrected average value W_{a1} is calculated by Formula (2) given above (Step S22). Steps S7A-S10A are the same as Steps S7-S10 of Fig. 2, and hence will not be explained again.

In summary, the average value W_a is corrected by the measured values W_j and W_{j+1} obtained j and $(j+1)$ times earlier, that is, by the recent change in the measured value ($W_j - W_{j+1}$). Thus, it is possible to respond more quickly to sudden changes in the weight of products.

Although the invention has been described above with reference to only a limited number of examples, these examples are not intended to limit the scope of the invention. Many modifications and variations are possible within the scope of the invention. For example, Formula (2) given above may be replaced by Formula (3) given below:

$$W_{a1} = W_a + A(W_j - W_a) + B \quad (3)$$

where A and B are constants, and the judging means 3 will compare the absolute value of $(W_a - W_j)$ with ΔW in Step S20 of Fig. 5.

Although it was shown in each of the examples described above that the standard value control means 15 of Fig. 1 controls the upper and lower limits of the standard value W_b , it may equally well control the upper and lower limits of allowable upper and low-

er limits $W_b + \alpha$ and $W_b - \beta$. Moreover, weighing and sorting means need not comprise a weighing conveyor and a sorting conveyor, respectively.

In summary, this invention teaches the introduction of a standard value control means to a weight checker-sorter and hence the standard value can be updated quickly when there is a sudden change in the weight of a product. As a result, sorting of products can be effected with improved accuracy.

Claims

1. A weight checker-sorter comprising a weighing means (1) for weighing a product expected to contain a specified plural number of articles; judging means (3) for determining whether or not said product, weighed by said weighing means (1), contains said specified plural number of said articles by comparing a measured weight value (W_i) obtained by said weighing means and a current standard value (W_b); weight memory means (11) for storing weight values of products which have been considered acceptable by said judging means (3); updating means (10) for calculating a new standard value from a plurality of weight values stored in said weight memory means; and sorting means (2) for sorting products weighed by said weighing means (1) according to determinations by said judging means (3); characterised in that said updating means (10) includes averaging means (12A) for calculating an average once every n' times as new weight values are stored in said weight memory means (11), said average being of the n most recently stored values, n and n' being integers, and n being greater than n' .
2. The weight checker-sorter of claim 1, wherein said averaging means (12A) performs a simple average of said n weight values.
3. The weight checker-sorter of claim 1, wherein said averaging means (12A) performs a weighted average of said n weight values.
4. The weight checker-sorter of any of claims 1 to 3, wherein said updating means checks whether or not said average (W_a) is greater than a predefined lower limit value (W_{bmin}) and whether or not said average is smaller than a predefined upper limit value $W_{(bmax)}$, and accordingly defines said average, said lower limit value or said upper limit value as said new standard value.
5. The weight checker-sorter of claim 4, wherein said updating means defines said average (W_a) as said new standard value if said average is larger than said lower limited value (W_{bmin}) but small-

er than said upper limit value $W_{(bmax)}$, said updating means defines said lower limit value (W_{bmin}) as said new standard value if said average is smaller than said lower limit value, and said updating means defines said upper limit value $W_{(bmax)}$ as said new standard value if said average is larger than said upper limit value.

6. The weight checker-sorter of any of the preceding claims, further comprising a standard value memory means (4) for storing said current standard value.
7. The weight checker-sorter of any of the preceding claims, wherein said averaging means includes correcting means (16) for correcting the value of said average to take into account of effects of sudden changes in said weight values.
8. The weight checker-sorter of claim 7, wherein said correcting means (16) corrects said average by the formula:

$$W_{a1} = W_a + \sum C_j (W_j - W_{j+1})$$
 where W_a and W_{a1} are the values of said average before and after correction, respectively; W_j is the j th most recently stored of said n weight values, j being a dummy index between 1 and $(n-1)$; \sum being a summation over such values of j for which the absolute value of $(W_j - W_{j+1})$ is greater than a predefined difference value; and C_j are predefined coefficients such that $C_j > C_{j+1}$.

Fig.1.

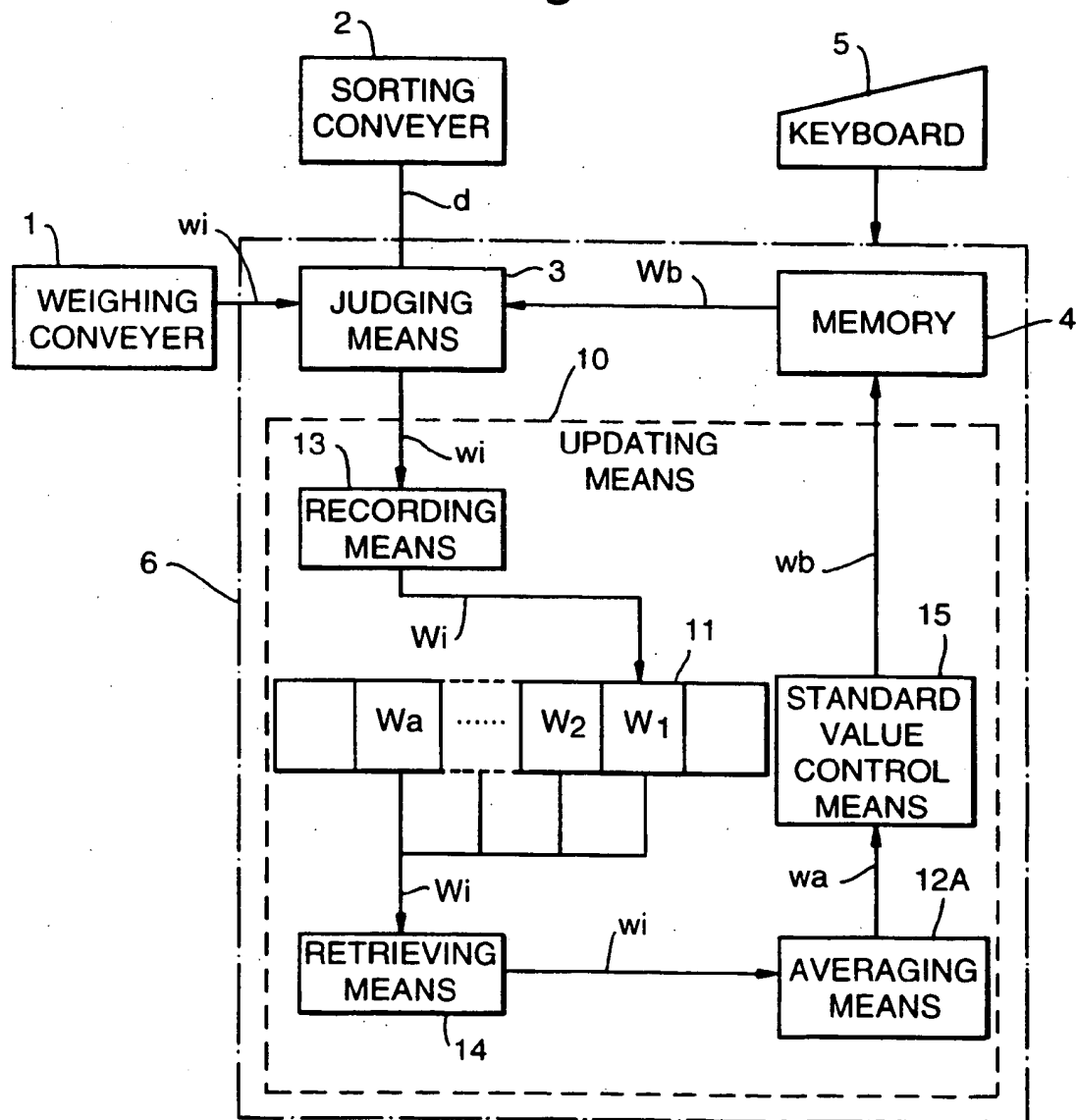


Fig.2.

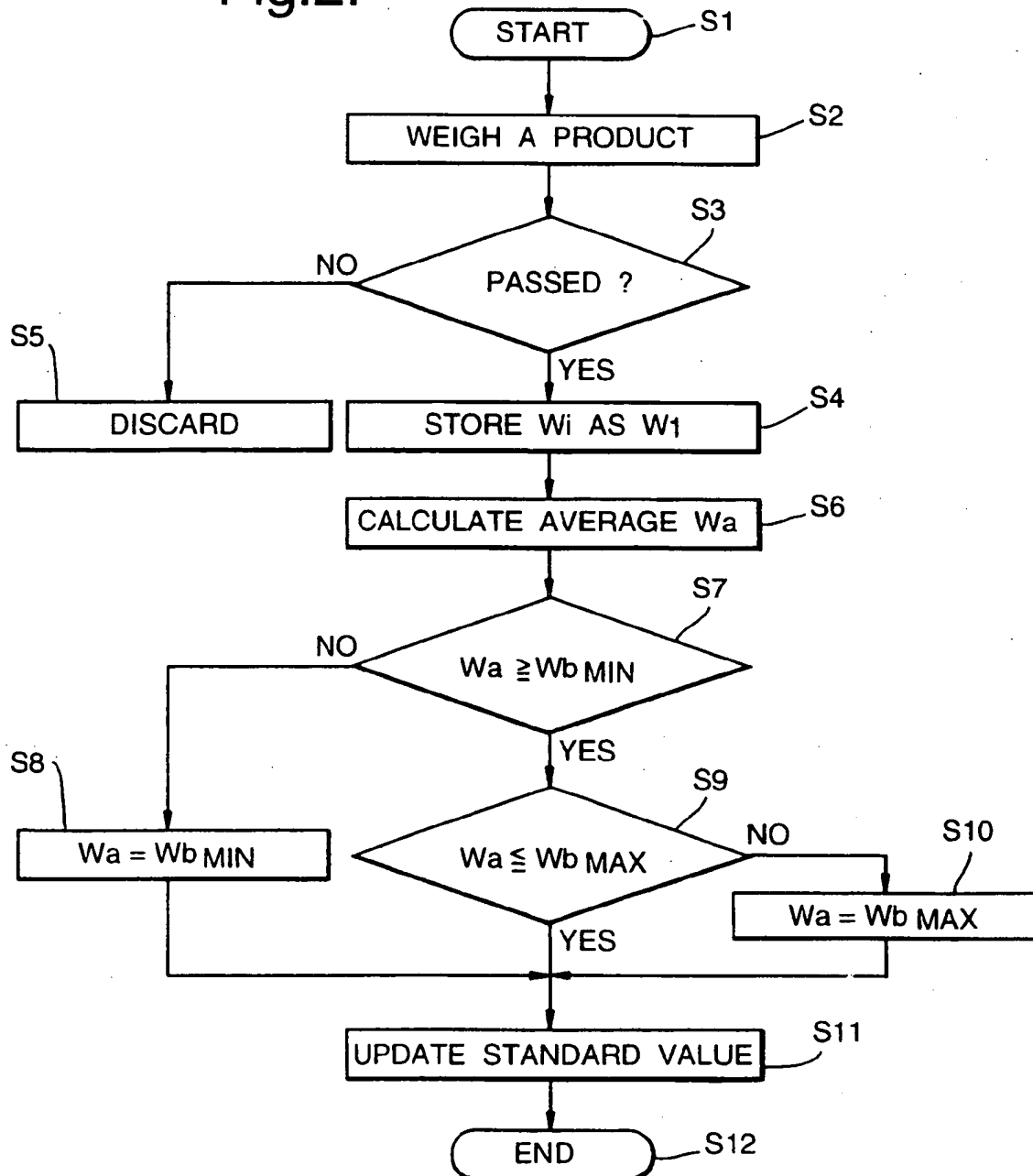


Fig.3(a)

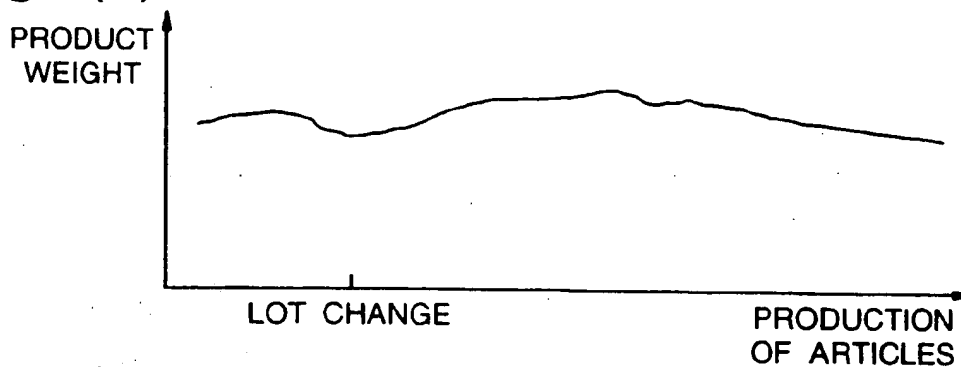


Fig.3(b)

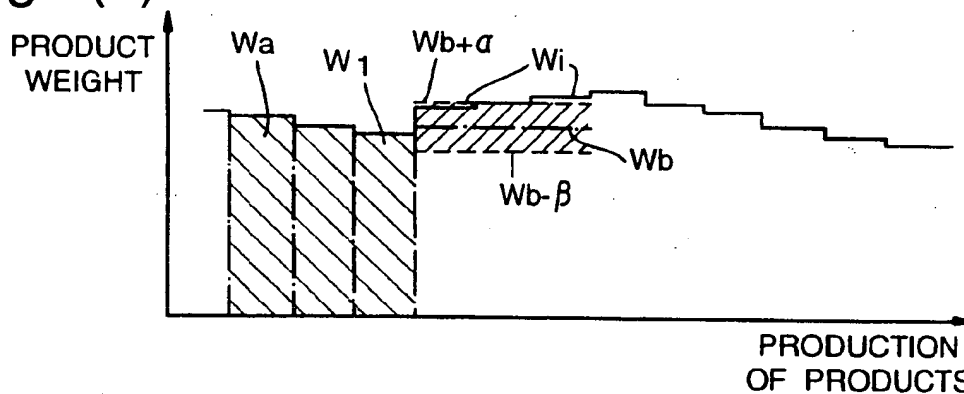


Fig.3(c)

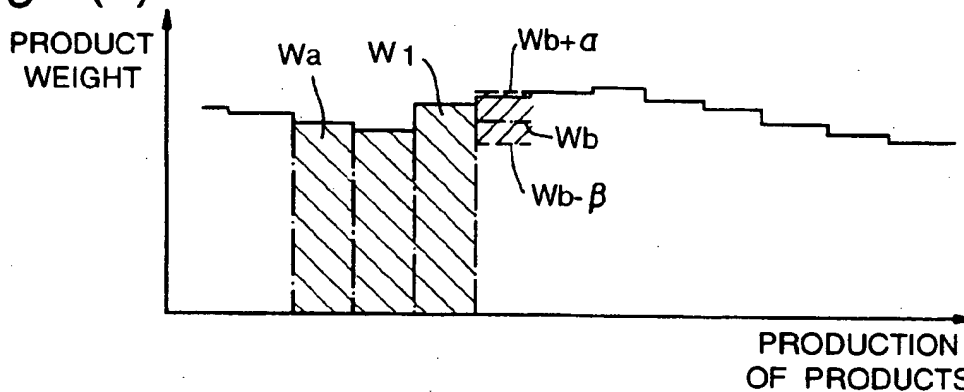


Fig.3(d)

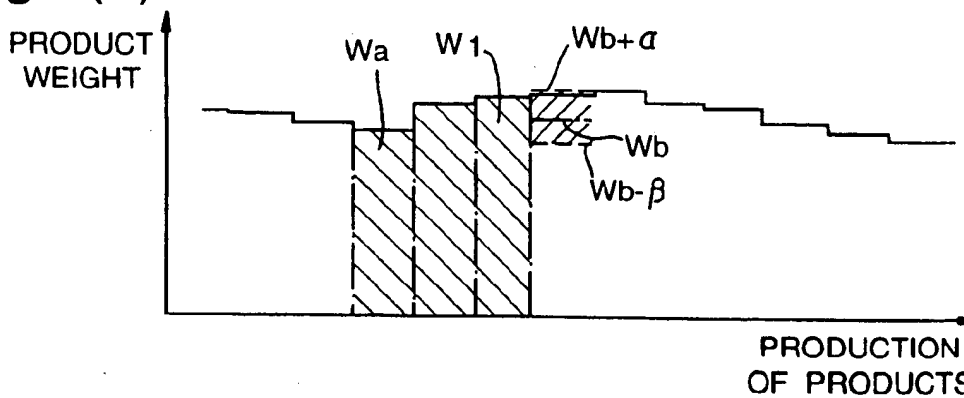


Fig.4.

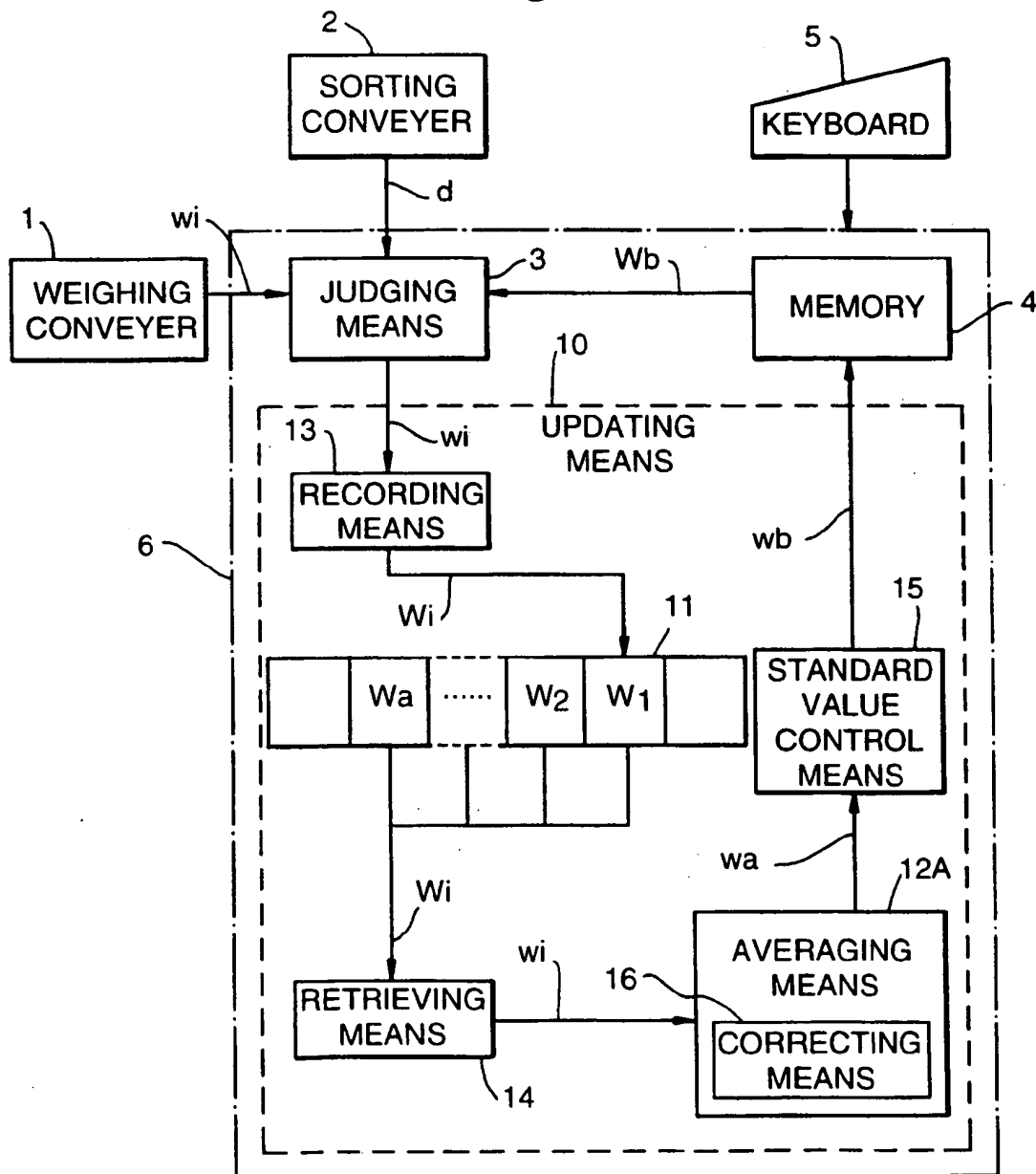


Fig.5.

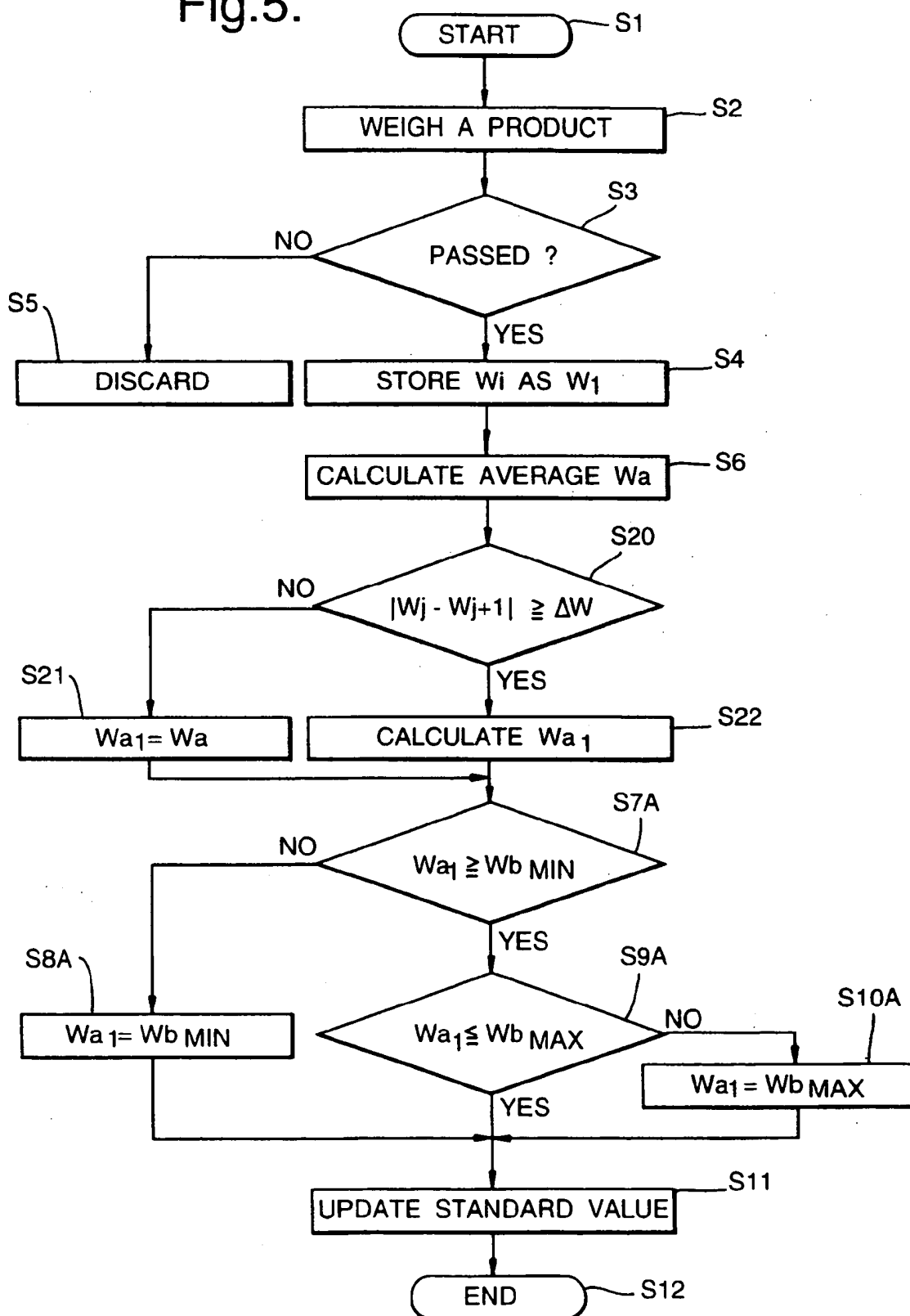


Fig.6.

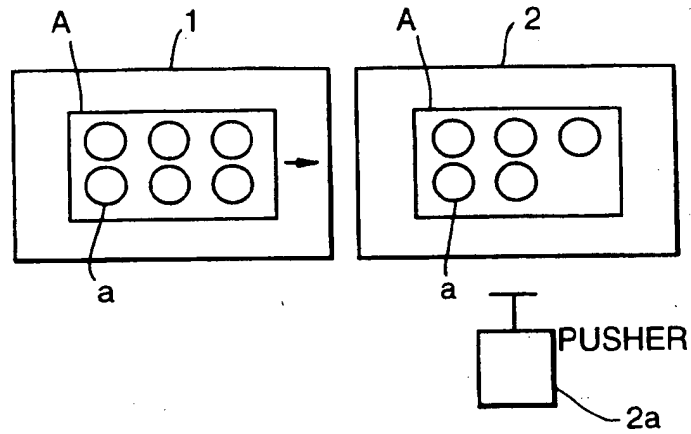


Fig.7.

(PRIOR ART)

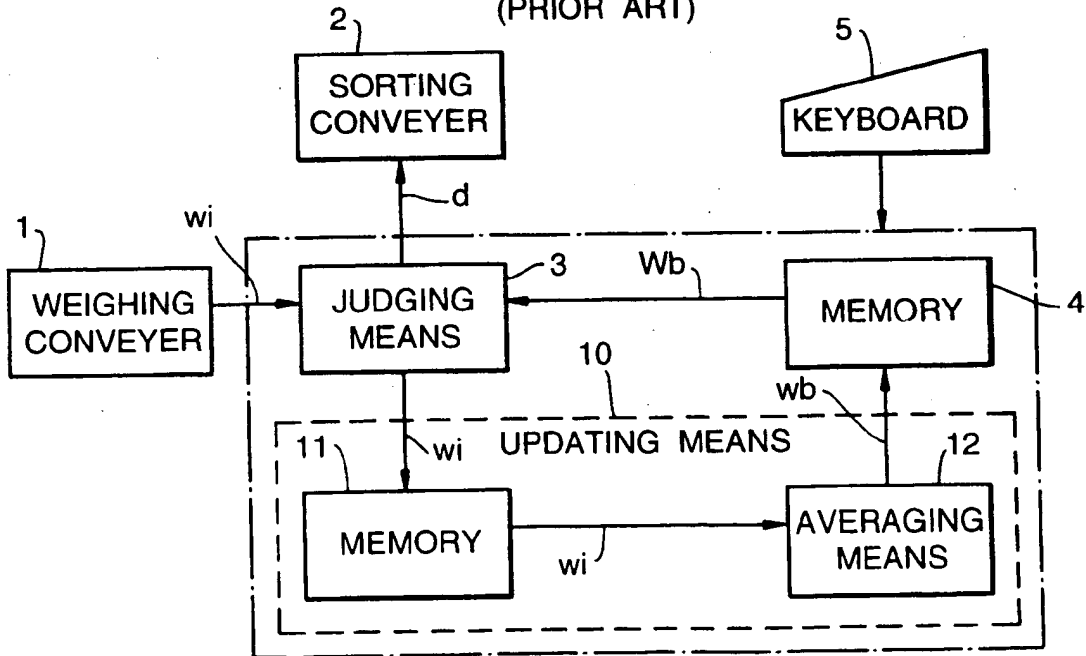


Fig.8(a)

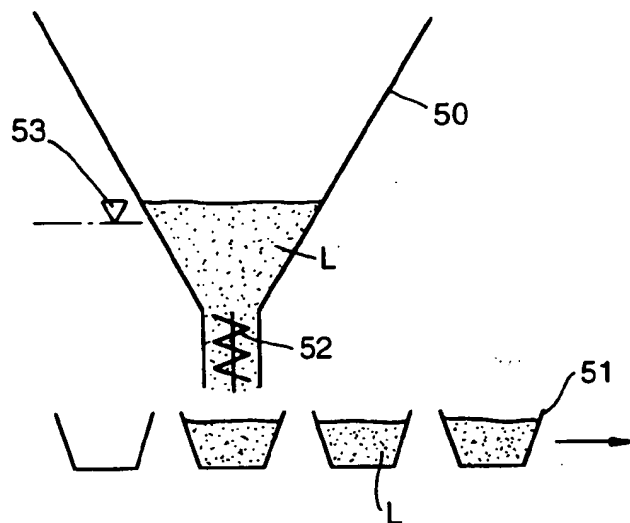
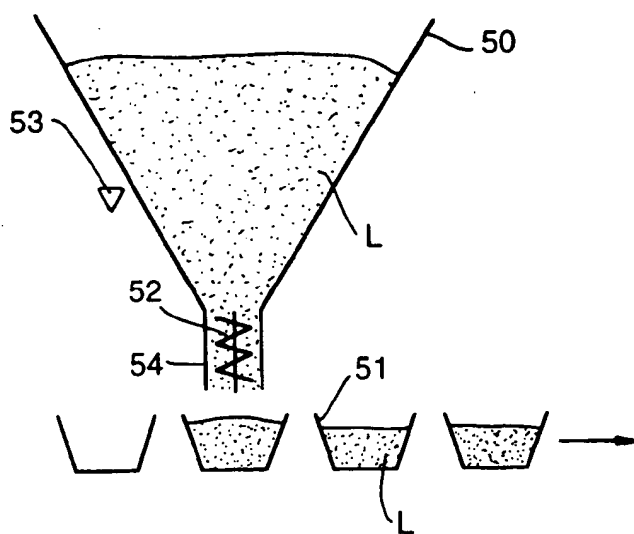


Fig.8(b)





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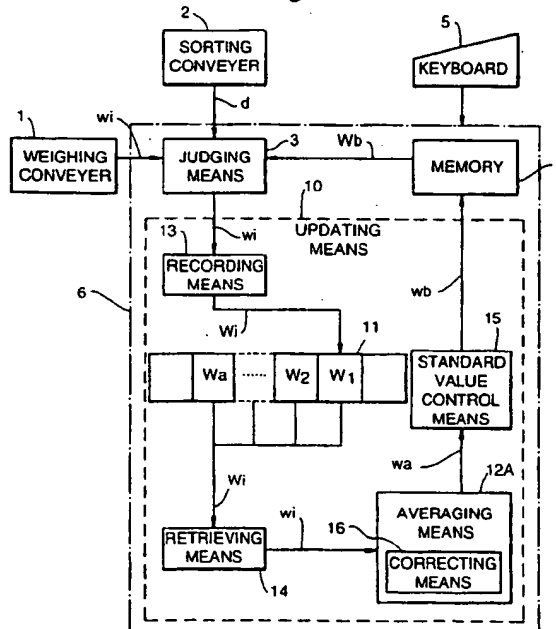
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54 Weight checker-sorter.

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Fig.4.





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EUROPEAN SEARCH REPORT

Application Number
EP 93 31 0301

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. CL.5)
A	US-A-4 696 329 (ANTHONY J. IZZI) * abstract *	1	B07C5/32 G01G15/00
A	WO-A-90 15755 (A.G.(PATENTS)LIMITED) * page 16, line 26 - page 17, line 29 *	1	
A	EP-A-0 369 357 (SOCIETE DES PRODUITS NESTLE S.A.) * abstract *	1	
			TECHNICAL FIELDS SEARCHED (Int. CL.5)
			G01G B07C
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 21 February 1995	Examiner Ganci, P
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